

slip 20/08

Dart Aerospace Ltd.

Date: Wednesday, 06/08/2008 2:06:22 PM  
User: Julie Lecocq

# Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SUPPORT ANGLE
Job Number	: 41022		
Estimate Number	: 13281		
P.O. Number	:	Part Number	: D36981
This Issue	: 06/08/2008 S.O. No. :	Drawing Number	: D3698 REVB
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: // Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 40666	Material	:
Written By	:	Due Date	: 28/08/2008
Checked & Approved By	: <u>JUL 08.8.08</u>	Qty:	5
Comment	: Est Rev:A 08-04-25 new issue DD verified by:EC Est Rev:B 08-07-14 revB as per dwg DD verified by:ec		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6S032	6061-T6 Sheet 0.032"
<p>Comment: Qty.: 0.4700 sf(s)/Unit Total : 0.9400 sf(s) 6061T6 aluminium sheet .032" thick (M6061T6S032) Batch: <u>16954</u> <u>1B 8-8-7</u></p>		
2.0	WATER JET	FLOW WATER JET
<p>Comment: FLOW WATER JET 1-Cut as per Dwg D3698 Dwg Rev: <u>3</u> <u>1B 8-8-7</u> Prog Rev: <u>B</u> ****grain direction along 1.378" **** 2- Deburr if necessary <u>1B 8-8-7</u></p>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p>		
4.0	QC8	SECOND CHECK
<p>Comment: SECOND CHECK <u>5 8/8/8</u> <u>(17)</u></p>		
5.0	BRAKE NC	NC BRAKE
<p>Comment: NC BRAKE 1-Bend 105 deg. angle as per Dwg D3698 <u>SB 08/08/12</u> <u>(7)</u></p>		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ANGLE

Job Number: 41022

Part Number: D36981

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-form curve as per dwg D3698 and verify using template DT9001

FF 02-08-19

(7)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/08/19 (X7)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

MJ

08/09/20

8.0

POWDER COATING

POWDER COATING



M 102316



(7X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

8:50

OVEN TEMPERATURE:

320 °C

FINISH TIME:

9:20

M-f

08/08/20

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR

08-08-20

(7X)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 143

CZ 08/08/21

(7)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/22

Job Completion



Mf 08-08-21

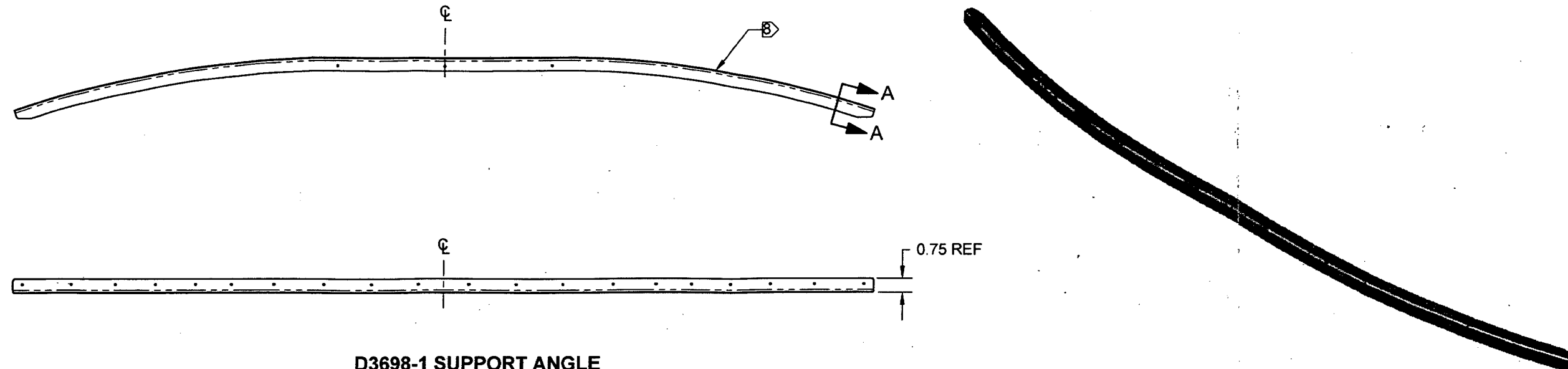
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

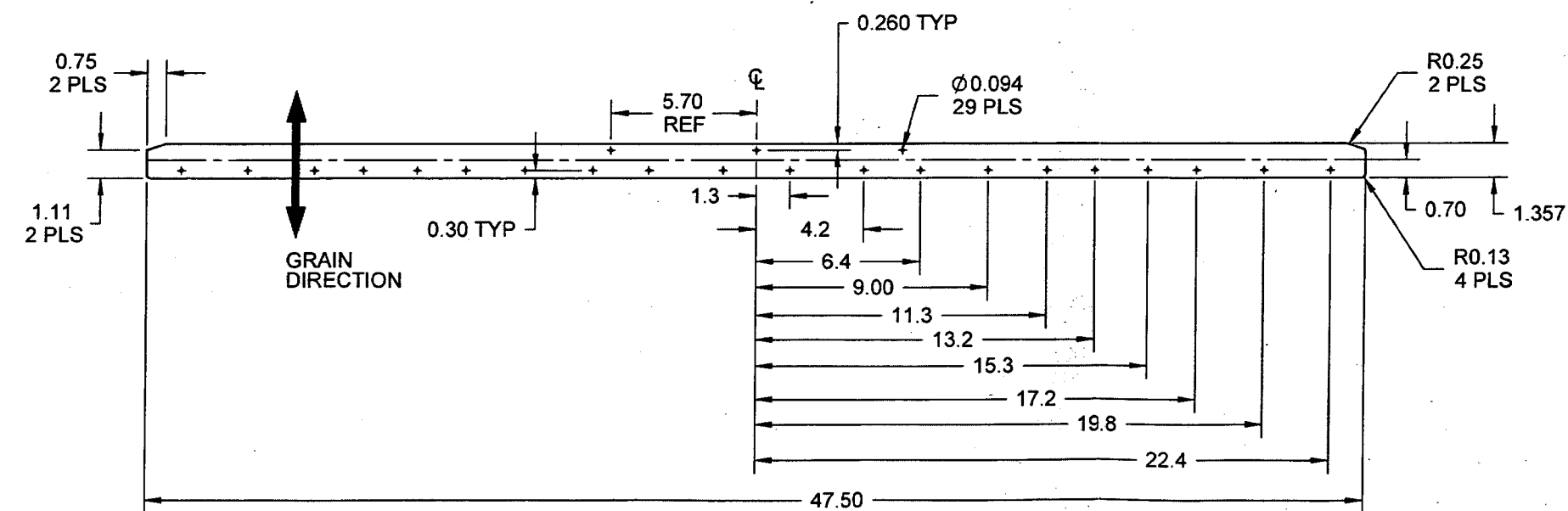
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

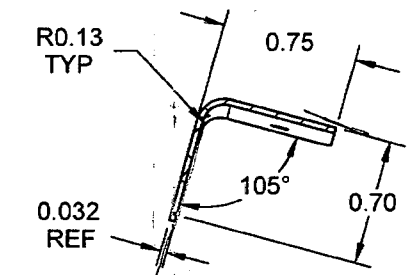
NOTE: Date & initial all entries



**D3698-1 SUPPORT ANGLE**  
(MAKE FROM D3698-1F FLAT PATTERN)



**D3698-1F FLAT PATTERN**



**SECTION A-A**

**RELEASED**  
08-07-08

- NOTES:**
- 1) MATERIAL: 6061-T6 (QQ-A-250/11) SHEET 0.032 THICK (REF. DART SPEC. M6061T6S.032)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: NONE
  - 7) WEIGHT: 0.20 lbs
  - 8) FORM AS PER TEMPLATE DT9001



B	REMOVE POWDER COAT. ZONE A,8	RF	08.06.02
A	NEW ISSUE	RF	08.05.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3698</b> TITLE <b>SUPPORT ANGLE</b> COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	RE		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.06.02	REV. B SHEET 1 OF 1 SCALE NTS	

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 41022



Non-Conformance Report				NCR 08-080	
Raised by: <u>Jason Murchloch</u>		Source: <u>Prod/Small med. Assy</u>		Sheet No. <u>1</u> of <u>1</u>	
Non-Conforming Dept./Supplier: <u>Production Small/Med. Fab.</u>				Date: <u>08.08.28</u>	
Product/Service: <u>D3698-1 → D3690-041</u>				Priority: <u>HIGH</u> <u>LOW</u>	
Area of Standard:		<b>Section A</b> <b>Description of Non-Conformance</b> ① 2 work orders of D3698-1 support angles were fabricated & inspected incorrectly. Parts were bent 105° on the outside, instead of 105° on the inside of the angle. B41022 & B40666 D3698-1 each affected. Root Cause:  ② Upon the installation of the D3698-1 onto the D3690-041, due to the D3698-1 being incorrect, the distance of 5.50" along the part could not be achieved, and Employee still continued to drill holes into the D3690-1's to resulting in 2 of the D3690-1's having incorrect holes. Also where to measure the 5.5" the CL is not very clear on the dwg.			
QSI					
QSP					
QSPM					
Documents:					
P/O		R.C.:  Forward to Director, Quality Assurance on completion of this box			
Invoice					
W/O					
Batch No. <u>41207</u>					
TSR					
Drawing <u>D3690-041</u>		DQA: Section B: Indicate who is responsible for creating C/A, and a completion date. Section C: Indicate who will verify completion of C/A.			
<u>Rev. B</u>					
<b>Section B</b>		Responsible for Investigation/CA: <u>M. He Petsche</u> To be done by: <u>08/09/15</u>			
<b>Corrective Action</b>					
No	Initial	Action Description	Responsible	Due date	Sign/Date
1	J.M.	Review the D3690-041 drawing to clarify the start & finish of the 5.50" measurement. * Place dwg under review & identify all w/o in production.	M.P.	08/08/28	
2	J.M.	Scrap & destroy D3698-1, B41022 & 40666	S. Bacher	08-08-28	
3	J.M.	Retrain Small Fab, and inspector, and review the D3698-1 dwg with them to ensure there is no confusion on how the part is made.	J. Murchloch	08-08-28	
4.					
Preventive Action Required: NO YES # _____			Fault Category: _____		
<b>Section C</b>					
Verification of C/A Responsible for Verification of CA: _____					
No	Verification Method	Sign	Date	Forward to DQA on Completion of Verification	
				DQA: _____	
				Date: _____	
QA Purposes only		N/C Closed		Date _____	